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**(54) MACHINE TOOL WITH HORIZONTAL SPINDLES**

WERKZEUGMASCHINE MIT HORIZONTALEN SPINDELN

MACHINE-OUTIL A BROCHES HORIZONTALES

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**JP-A-61 095 845** **US-A- 3 789 473**  
**US-A- 5 372 568**

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**Description**

[0001] The invention is directed to a machine tool for the drilling and/or grinding treatment of workpieces, comprising at least two headstocks.

[0002] Machine tools are known wherein the headstock removes or resp. returns the tools directly from/into a fixed or movable tool magazine. In such machine tools, the headstock must be advanced to the tool magazine upon completion of a treatment process. At the tool magazine, the tools are exchanged, and the headstock is subsequently guided back to the workpiece. The exchanging of tools requires a considerable length of time, which is caused not only by the movement processes to be performed by the headstock but also by the time losses due to the decelerating and accelerating of the working spindle. Throughout the exchanging of tools, the machine tool is not available for treatment processes.

[0003] In machine tools comprising a large number of working spindles in a revolver configuration, the removing of one working spindle from the workpiece and the advancing of another working spindle to the workpiece along with the coupling and accelerating processes takes considerable time. Although, during operation of one working spindle, another working spindle can be equipped with new tools, this will require a high expenditure in working spindles. Further, such an approach necessitates the use of a tool magazine which is advanced to the revolver system located in its operating position.

[0004] JP 59-69242 A (Patent Abstracts of Japan M-317, August 15, 1984, Vol. 8, No. 177) discloses a machine tool with a support in which two headstocks are movable in the vertical direction independently of each other. Each headstock has a dedicated tool magazine arranged thereabove which is moved together with the headstock. The transfer of the tools from a tool magazine to the appertaining headstock is performed by a swivel arm. The whole support of the machine tool is displaceable in the direction of tool feed. This machine tool offers the advantage that a respective one of the headstocks can engage the workpiece while an exchange of tools can be carried out on another headstock. Thus, considerable time is saved because no time is lost during tool exchange.

[0005] A machine tool forming the basis of the preamble of claim 1 is known from JP-A-61095845. This machine tool has a vertically movable subframe carrying two headstocks, each of them movable in the longitudinal direction of the headstock. Further, the subframe carries a tool magazine and a transfer device, both mounted on a common carriage that is movable in the horizontal direction so as to assign the tool magazine to one or the other headstock. The transfer device transfers tools between the tool magazine and the corresponding headstock.

[0006] US-A-5 372 568 discloses a machine tool hav-

ing one headstock mounted on a vertically movable carriage, and a tool magazine is rotatably mounted on the column of the machine tool. The headstock may be moved upward for performing a direct tool change with the tool magazine.

[0007] Further, a machine tool known from Patent DD 263 725 A1 comprises a single headstock to be displaced vertically on the support. Additionally, the headstock can be moved horizontally in its longitudinal direction to allow exchange of tools using a tool magazine. The tool magazine is arranged before the machine support and carries various tools on a horizontally moveable slider, such that each tool can be moved into a transfer position for the headstock. The guiding path for the tool magazine must be at least twice as long as the magazine slider carrying the tools.

[0008] It is an object of the invention to provide a machine tool which is very straightforward in construction and allows a very quick exchange of tools.

[0009] According to the invention, the above object is solved by the features indicated in claim 1.

[0010] In the machine tool of the invention, two headstocks are movable independently of each other on the support along vertical guides. Further, each headstock is movable horizontally in its longitudinal direction. While one of the headstocks carries out a treatment on the workpiece by means of a tool, the other headstock is free to move to a workpiece magazine, deposit the old tool and take up a new tool. When the headstock performing the treatment has finished its operation, it will be retreated, and the headstock carrying the new tool will be applied to the workpiece. In this manner, the tool exchange time after completion of a treatment step can be limited to that length of time which is normally needed for the process from one operating position to the next one. Thus, nearly no additional time or no time at all is required for exchanging the tools. The exchange of tools can be carried out in about one second. Treatment of the workpieces is performed by alternative operation of the two headstocks, wherein respectively one headstock is active in treating the workpiece while the other either performs an exchange of tools or is kept waiting in a standby position.

[0011] The tool magazine provided in common for both headstocks has two exchange positions, i.e. one for each headstock. Under automatic control of the tool magazine, the individual tools are moved into the exchange position for the respective headstock for which they are determined. The headstocks are guided behind the tool magazine to take over the tool positioned in the exchange position, by carrying out a simple advance movement. Therefore, no transfer devices are required between the tool magazine and the headstock. The tool magazine has a short constructional length and a high storing capacity for tools, both headstocks being serviced by the horizontal lower strand of the circulating magazine, with the exchange positions being arranged at the same height.

[0012] The double arrangement of the headstocks provides for a decoupling between the moving sequence for treatment (essential operating time) and the exchange of tools (auxiliary process time). Through the alternating use of the respective headstock equipped with the new tool and accelerated to the operating rotational speed, the nonproductive auxiliary process times are practically eliminated. Because of said decoupling effect, the moving processes involved in the exchanging of tools can be determined in such a manner that acceleration jumps and jolts are largely prevented, especially during run-up and slow-down of the working spindle of a headstock, during magazine and tool clamping movements and during axial movement of the headstock for tool exchange. Thus, the lifespan of the mechanical and electrical components is increased.

[0013] The headstocks can be designed for different power specifications, the respective current task being performed by that headstock which is suited for the treatment process in question. Thus, for instance, one headstock can be dimensioned for power machining by means of large grinding tools, and the other one can be dimensioned for the use of high-speed drilling tools.

[0014] A further advantage resides in that the operability of the machine tool is still maintained even in case of failure of one headstock, although more time will be required in this case for the exchange of tools. Further, it is possible under certain conditions to treat two workpieces simultaneously and in parallel.

[0015] Preferably, the support of the machine tool is a portal support comprising two vertical posts and a crosshead. In this arrangement, the guiding paths of the headstocks are located on the mutually confronting inner sides of the posts. Alternatively, use can be made of a support which consists of a single post and wherein the guiding paths of the spindle heads are located on the mutually averted outer sides. The tool magazine is arranged in an advanced position on the front side of the support.

[0016] Preferably, the tool magazine is arranged on the upper end of the support, although it can likewise be arranged on the lower end, e.g. in the base portion of the machine. If the tool magazine is provided on the upper end of the support, the large height will make it difficult for the operating person to load the tool magazine with tools. According to a preferred embodiment of the invention, the tool magazine can be pivoted about an axis near one of its ends to thus lower the other end into a loading position.

[0017] The machine tool preferably comprises a workpiece carrier which transversely to the lengthwise orientation of the headstocks is displaceable in a horizontal direction. A machine tool of this type constitutes a self-contained treatment unit. By integration of the workpiece carrier into a transfer line, the machine can also be used as a flexible working station in interlinked systems.

[0018] Preferably, the controlling of the machine tool is

performed completely in numerical fashion, i.e. all of the moving processes of the headstocks, the tool magazine and the workpiece carrier are controlled according to a predetermined program sequence and are coordinated with each other, so that all movements are carried out automatically.

[0019] An embodiment of the invention will be explained in greater detail hereunder with reference to the drawings.

Fig. 1 is a partially cut-out perspective view of the machine tool,

Fig. 2 is a side view of the machine tool, with the upper portion and the tool magazine viewed in cross section, and

Fig. 3 is a partial view of Fig. 1, with the tool magazine pivoted down into the loading position.

[0020] According to Fig. 1, the machine tool comprises a support 10 projecting from a base 11. Support 10 is provided as a portal support comprising two mutually spaced vertical posts 12 having their upper ends connected to each other by a crosshead 13.

[0021] Arranged on the mutually confronting inner sides of the posts 12 are vertical guides 14 for respectively one vertically movable slider 15. Each slider 15 comprises a horizontal guide for horizontal movement of a headstock 16 or resp. 17 therealong. Within the headstock 16 or resp. 17, there is arranged a drive unit for a working spindle 18 which projects from the front end of the headstock and comprises a receiving portion for a tool.

[0022] In front of support 10, a workpiece carrier 20 is arranged on base 11 in a manner allowing displacement along a horizontal guide means 21 transversely to the lengthwise direction of headstocks 16 and 17. This moving direction of workpiece carrier 20 is the X-direction, the vertical direction is the Y-direction and the longitudinal direction of headstocks 16,17 is the Z-direction.

[0023] In the illustrated embodiment, the workpiece carrier 20 is movable exclusively in the X-direction. The movements in the Y- and Z-directions are carried out by the respective headstock.

[0024] Workpiece carrier 20 can be provided with a rotary table, a turning arrangement, a pallet clamping device, a pallet exchange device and the like. It is imperative that the workpiece carrier 20 be able to receive and position the workpiece in an exactly defined manner.

[0025] Drive units 22,23 for the vertical movements of headstocks 16,17 are arranged on crosshead 13. The headstocks are individually displaceable independently from each other in Y- and Z-directions. While, for instance, headstock 17 is involved in treatment of a workpiece, headstock 16 can be moved into a take-up

position for tool exchange.

[0026] A tool magazine 24 is arranged in an advanced position (i.e. in front of the support) at a fixed height on support 10. The tool magazine comprises an endless conveying means, i.e. a chain, arranged for endless movement in a vertical plane and having outwardly projecting tool holding units 25 attached thereon. Tool magazine 24 is of an elongate shape, and those of the tool holding units 25 which project from the horizontal lower strand can be engaged by the headstocks. The tool holding units 25 are provided with gripper arms for holding respectively one tool 26.

[0027] As shown in Fig. 2, 'headstock 16 can be moved upwards into a takeover position UP behind tool magazine 24. The takeover position is the upper end position of headstock 16 in the Y-direction and at the same time the rear end position in the Z-direction. In the takeover position, the spindle 18 is in axial alignment behind that tool 26 which is in the exchange position WP in the horizontal lower strand of tool magazine 24. When headstock 16 is slightly advanced out of takeover position UP in the direction of the Z-axis, headstock 16 seizes the rear end of tool 26 by the receiving portion of working spindle 18. Simultaneously, tool 26 is being secured in working spindle 18. Subsequently, the headstock 16 can move downwardly and, in doing so, detach the tool 26 from the tool magazine 24. At the height of its lower strand, tool magazine 24 has two exchange positions, notably one for each headstock.

[0028] To make it easier for an operating person to manually load tools into the tool magazine 24 arranged on the upper end of support 10, the tool magazine can be pivoted about a horizontal pivot axis 30 which is schematically indicated - although not explicitly shown - in Fig. 1. The pivot axis 30 is arranged in the vicinity of one end of the elongate tool magazine. When pivoting the tool magazine about pivot axis 30, it will take the pivoting position shown in Fig. 3 wherein the end 24a has been pivoted downwards. Thus, the tools 26 near the downwardly pivoted end 24a are easily accessible. For pivoting the tool magazine, a cylinder 31 is arranged on crosshead 13. The chain of tool magazine 24 is driven by a numerically controlled drive unit so that the individual tool holding units 25 can be moved respectively into the desired position.

[0029] The tool magazine 24 is covered by a hood 32 attached on the upper end of support 10 and being open only in downward direction.

#### Claims

1. A machine tool comprising a support (10) having two headstocks (16,17) arranged thereon to be moved in their longitudinal direction horizontally on the support (10), and for both headstocks (16,17) a common tool magazine (24) positioned on the front side of the support (10) and being arranged as a circulating magazine,

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characterized in that

the headstocks (16,17) are movable independently of each other along vertical guides of the support (10).

the circulating magazine (24) is of elongated shape with a circulating endless conveying means and has on the lower strand thereof two exchange positions (WP), one for each tool magazine, and

each of the headstocks (16,17) is movable into a take-over position (UP) for receiving from the tool magazine (24) a tool that is in one of the exchange positions (WP) of the tool magazine.

2. The machine tool according to claim 1, characterized in that the tool magazine (24) is arranged at a fixed height on the upper end of the support (10).

3. The machine tool according to claim 1 or 2, characterized in that the tool magazine (24) can be pivoted about a pivot axis (30) near one of its ends to lower the other end into a loading position.

4. The machine tool according to any one of claims 1-3, characterized in that a workpiece carrier (20) is arranged in front of the support (10), to be horizontally displaceable transversely to the lengthwise direction of the headstocks (16,17).

5. The machine tool according to any one of claims 1-4, wherein each headstock (16,17) is axially movable in its take-over position (UP) in the longitudinal direction of said headstock for taking over a tool situated in one of the exchange positions (WP) of the tool magazine (24).

#### Patentansprüche

1. Werkzeugmaschine mit einem Ständer (10), an dem zwei Spindelstöcke (16,17) derart angeordnet sind, daß sie an dem Ständer (10) in ihrer Längsrichtung horizontal verfahrbar sind, und mit einem für beide Spindelstöcke (16,17) gemeinsam vorgesehenen Werkzeugmagazin (24), das an der Vorderseite des Ständers (10) positioniert ist und als Umlaufmagazin ausgebildet ist,  
dadurch gekennzeichnet, daß

die Spindelstöcke (16,17) unabhängig voneinander längs vertikaler Führungen des Ständers (10) verfahrbar sind,

das Umlaufmagazin (24) eine längliche Form mit einem umlaufenden Endlos-Förderer aufweist und an seinem Untertrum zwei Wechsel-

- positionen (WP) aufweist, und zwar für jedes Werkzeugmagazin eine, und
- jeder der Spindelstöcke (16,17) in eine Übernahmeposition (UP) bewegbar ist, um ein in einer der Wechselpositionen (WP) des Werkzeugmagazins befindliches Werkzeug aus dem Werkzeugmagazin (24) aufzunehmen.
2. Werkzeugmaschine nach Anspruch 1, dadurch gekennzeichnet, daß das Werkzeugmagazin (24) am oberen Ende des Ständers (10) in fester Höhe angeordnet ist.
3. Werkzeugmaschine nach Anspruch 1 oder 2, dadurch gekennzeichnet, daß das Werkzeugmagazin (24) um eine Schwenkachse (30) in der Nähe seines einen Endes schwenkbar ist, um das andere Ende in eine Bestückungsposition abzusenken.
4. Werkzeugmaschine nach einem der Ansprüche 1-3, dadurch gekennzeichnet, daß vor dem Ständer (10) ein Werkstückträger (20) angeordnet ist, der quer zur Längsrichtung der Spindelstöcke (16,17) horizontal verfahrbar ist.
5. Werkzeugmaschine nach einem der Ansprüche 1-4, bei der jeder Spindelstock (16,17) in seiner Längsrichtung axial in seine Übernahmeposition (UP) bewegbar ist, um ein in einer der Wechselpositionen (WP) des Werkzeugmagazins (24) befindliches Werkzeug zu übernehmen.

#### Revendications

1. Machine outil comprenant un support (10) sur lequel sont agencées deux poupées fixes (16, 17) devant être déplacées dans leur direction longitudinale, horizontalement sur le support (10), et pour les deux poupées fixes (16, 17) un chargeur d'outils commun (24) positionné sur la face avant du support (10) et agencé comme chargeur circulant, caractérisée en ce que
- les poupées fixes (16, 17) peuvent se déplacer indépendamment l'une de l'autre le long des guides verticaux du support (10).
- le chargeur circulant (24) est de forme allongée avec des moyens de transport sans fin circulants et présente sur son fil inférieur deux positions de remplacement (WP), une pour chaque chargeur d'outils, et
- chacune des poupées fixes (16, 17) peut se déplacer dans une position de réception (UP) pour recevoir depuis le chargeur d'outils (24) un outil qui est dans une des positions de remplacement (WP) du chargeur d'outils.

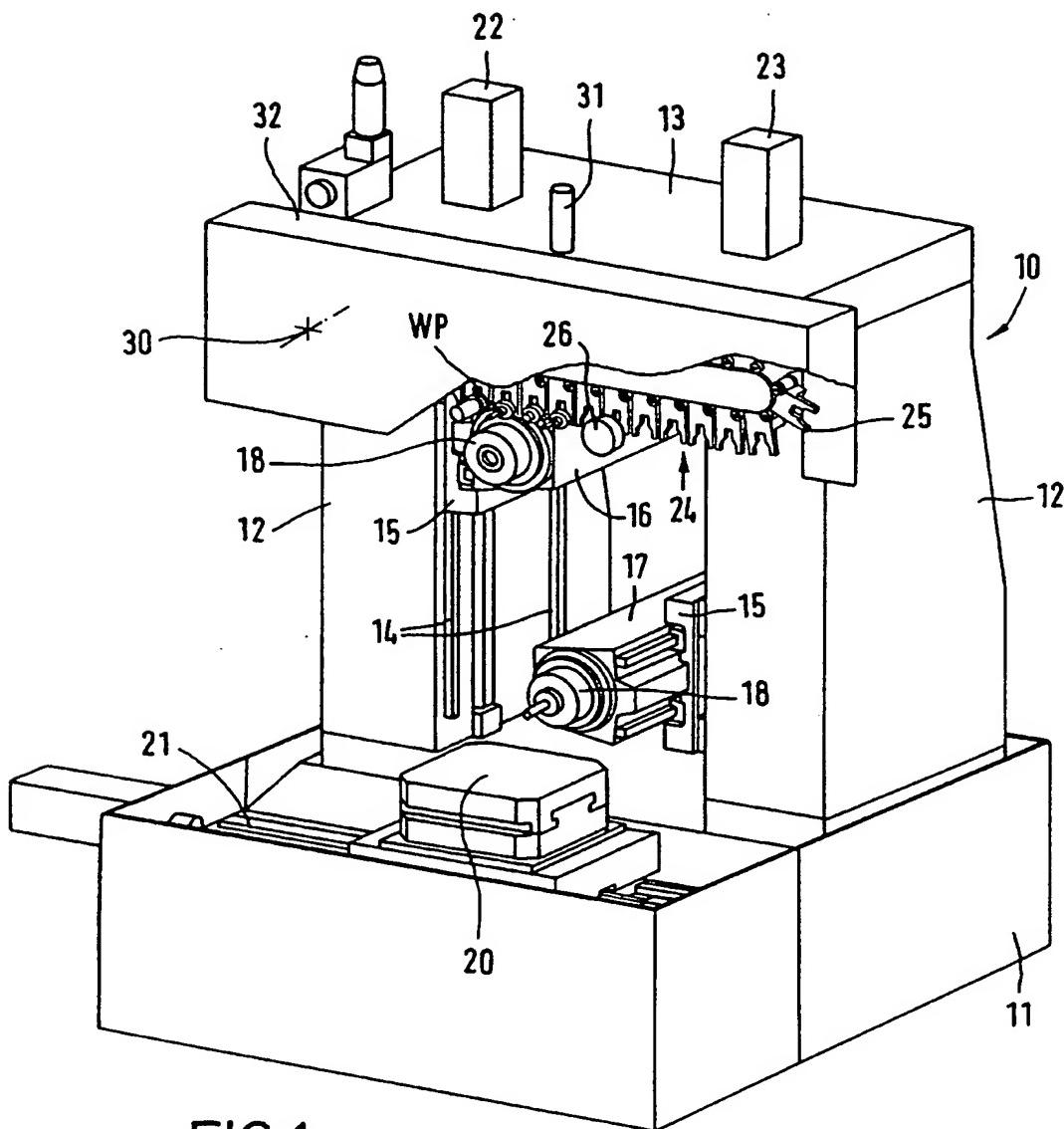
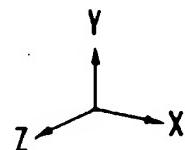


FIG.1



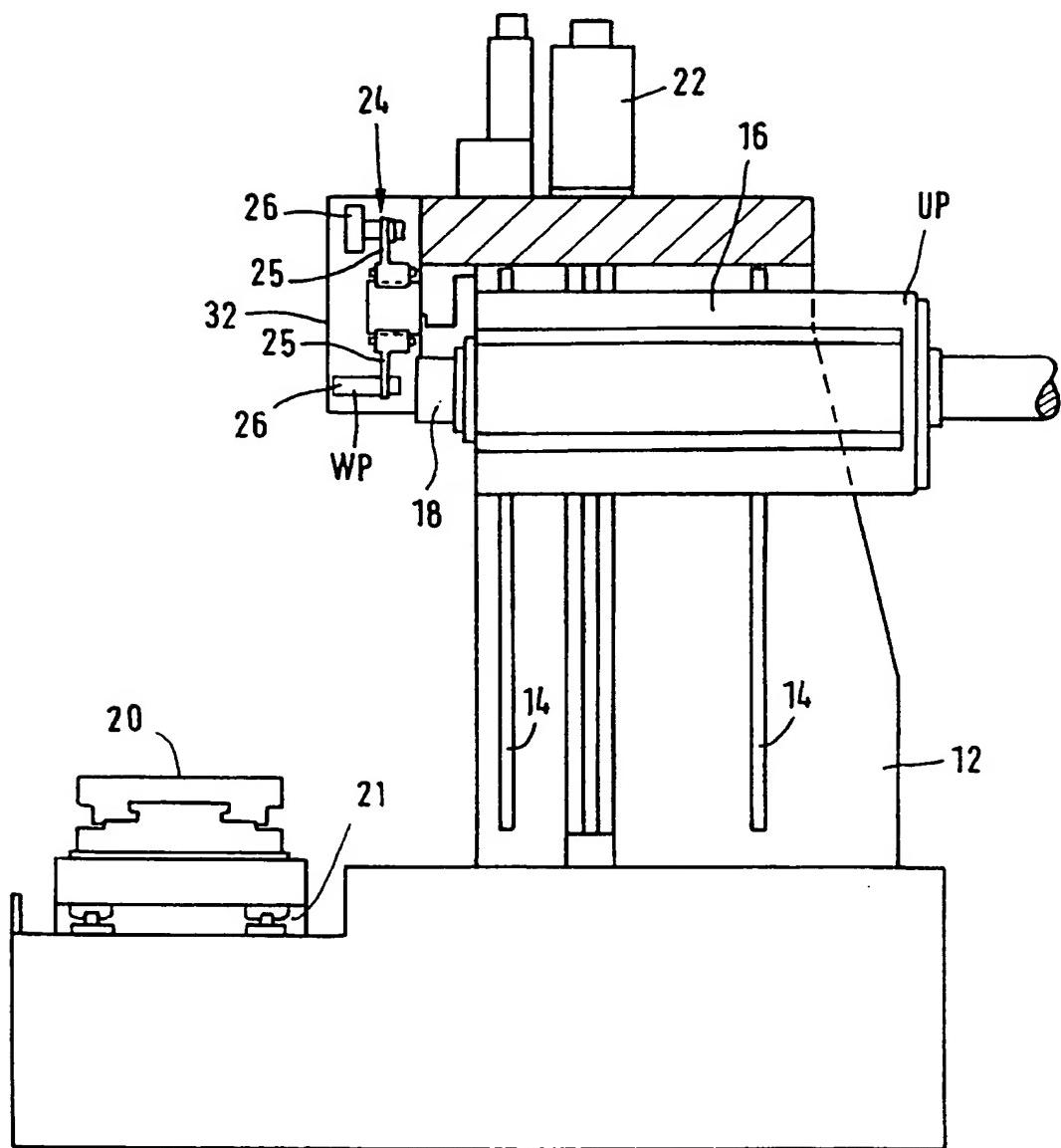
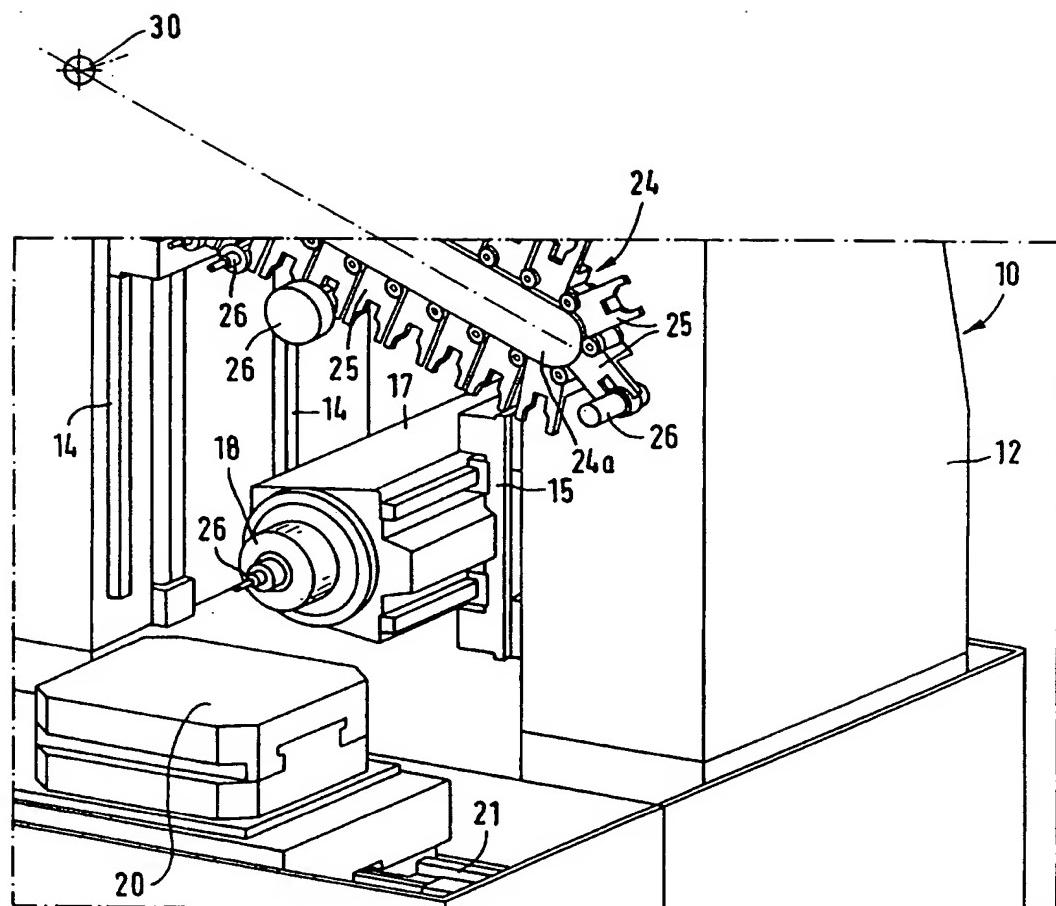


FIG. 2



**FIG. 3**